Work Order ID 94138 *94138* Page 1

November-30-12 9:27:56 AM

Item ID: D3651-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Top Flange

Start Date: 12/14/12 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 12/21/12 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 12-12-03 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3651	**Revision Nbr** Rev B								
100	FLOW WATER JET	0.00							
100 Waterjet	**Memo**	0.00				4		B12-12-11	
FLOW CNC Waterjet	1-Cut as per Dwg D3651								
304 .018"	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110 QC	**Memo**	0.00				4		B12-12-11	
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120 QC	**Memo**	0.00				4	12-12-11		DAS 09 12-89
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Work Order ID 94138

November-30-12 9:27:56 AM

94138

Item ID: D3651-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Top Flange

Start Date: 12/14/12 **Start Qty:** 4.00 *4*

Required Date: 12/21/12 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Form as per dwg	0.00							
160	NC BRAKE					4			13/01/08
Brake NC	**Memo**	0.00							
Brake NC									
170	QC5- Inspect part completeness to step on W/O	0.00 DAS 15 9-89							
170						4			
QC	**Memo**	0.00 13-1-8							
Quality Control									
180	Identify as per dwg & Stock Location: W/O	0.00							
180						4	G2	13-1-10	
Packaging	**Memo** 95306	0.00							
Packaging									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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☐ Drawing
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☐ Folio

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☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
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☐ Offset
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☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

Work Order ID 94138

November-30-12 9:27:56 AM

94138

Item ID: D3651-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Top Flange

Start Date: 12/14/12 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 12/21/12 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00					13/1/14		
190									
QC	**Memo**	0.00							
Quality Control									

MF

13-1-11

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Picklist Print

November-30-12 9:27:56 AM

Work Order ID: 94138

Parent Item: D3651-5

Parent Item Name: Top Flange

Start Date: 12/14/12 **Required Date:** 12/21/12

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP RevA 10.11.04 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA 304/316 0.018 SHEET		Purchased	No			100	sf	378.9700	**0.3**	**1.263158**		12-12-11	

Location	Loc Qty	Loc Code	
MAT020	378.97		
117798	35.06		
122753	87.91		122753
123135	256		

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

DART AEROSPACE LTD	Work Order:	94138
Description: Top Flange	Part Number:	D3651-5
Inspection Dwg: D3651 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

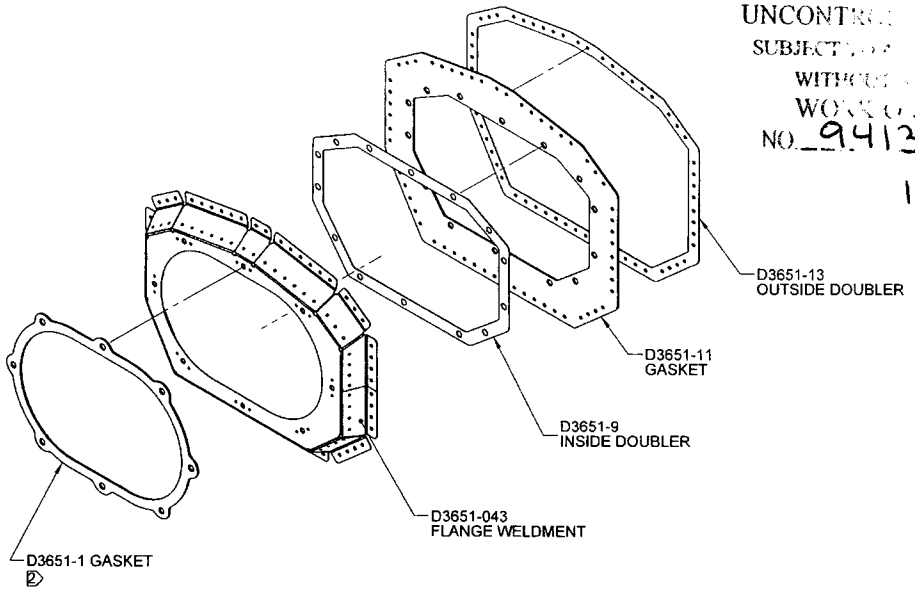
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.099	4		V BC	
Ø0.129	+0.005/-0.001	.131	2		V	
0.26	+/-0.030	.263	2		V	
0.26	+/-0.030	.263	2		V	
2.21	+/-0.030	2.212	2		V	
1.66	+/-0.030	1.656	2		V	
3.16	+/-0.030	3.163	2		V	
0.36	+/-0.030	.355	2		V	
0.33	+/-0.030	.331	2		V	
0.500	+/-0.010	.503	2		V	
0.33	+/-0.030	.328	2		V	
0.500	+/-0.010	.498	2		V	
0.450	+/-0.010	.450	2		V	
0.19	+/-0.030	.197	2		V	
0.98	+/-0.030	.983	2		V	
0.48	+/-0.030	.481	2		V	
0.25	+/-0.030	.253	2		V	

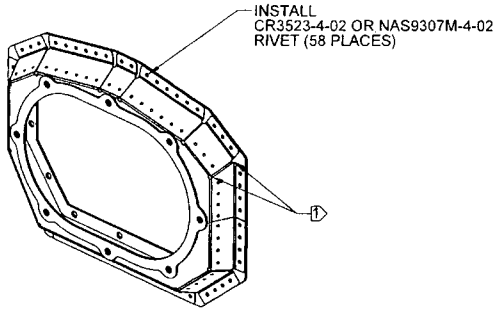
Measured by:	IB
Date:	12-12-11

Audited by:	DAS 09
Date:	12-12-11

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change		Revised by	Approved
A	08.10.07	New Issue	P/O D3651-043	KJ/DD	





SIGNED
REVIEWED
ENGINEERING
UNCONTROLLED
SUBJECT TO
WITHOUT
WORKS ORDER
NO. 94138 MLJ
12-12-03

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	**D3651-041**	**AFT BASE ASSEMBLY**
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

RELEASED
08.03.27 MD

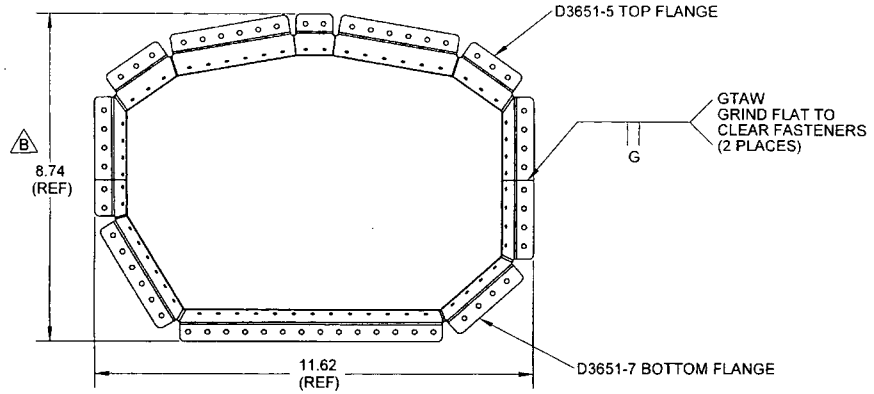
D3651-041 AFT BASE ASSEMBLY

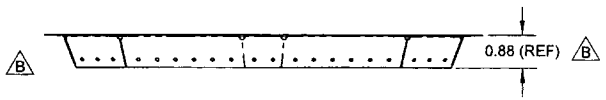
D3651-041 NOTES:
1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.6 lbs

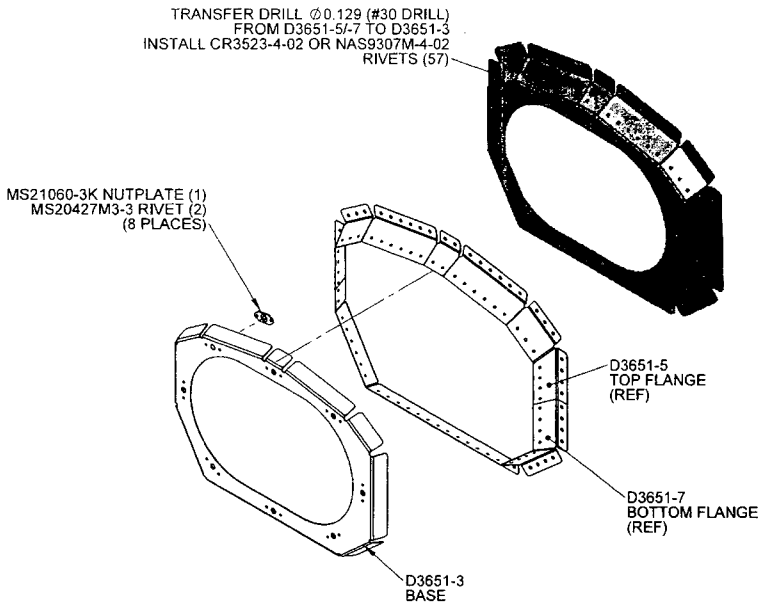
REV.	DESCRIPTION	BY	DATE
B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07

DESIGN	RF	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3651	REV. B
MFG. APPR.			SHEET 1 OF 9
APPROVED		TITLE AFT BASE ASSEMBLY	SCALE 1:4
DE APPR.			
DATE	08.01.07		

94138







QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET

D3651-043 FLANGE WELDMENT

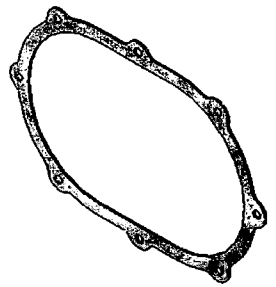
D3651-043 NOTES:
1) WELD PER QSI 004
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.76 lbs

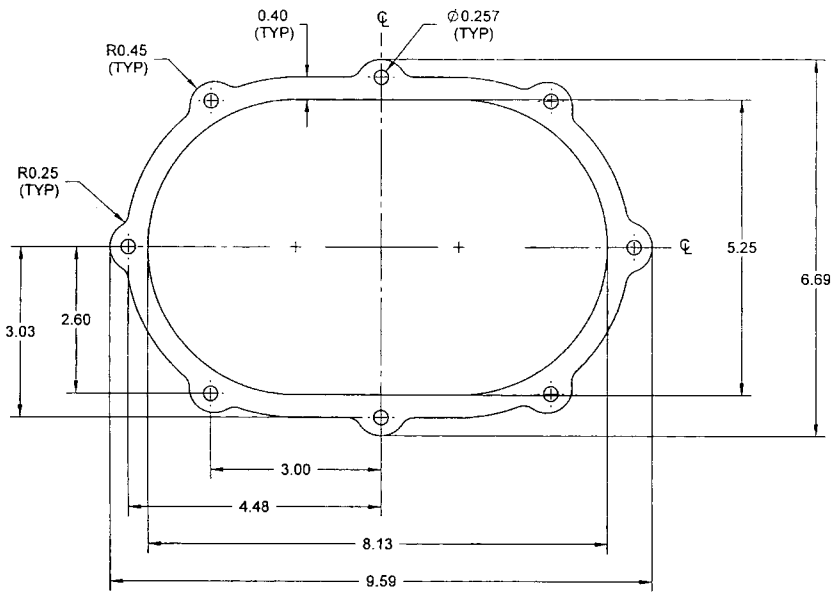
DESIGN	RF
DRAWN	RF
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.01.07

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3651 REV. B
SHEET 2 OF 9
TITLE AFT BASE ASSEMBLY SCALE 1:3

94138





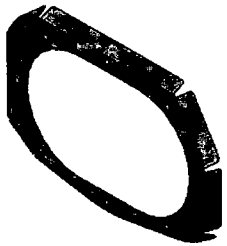
D3651-1 GASKET

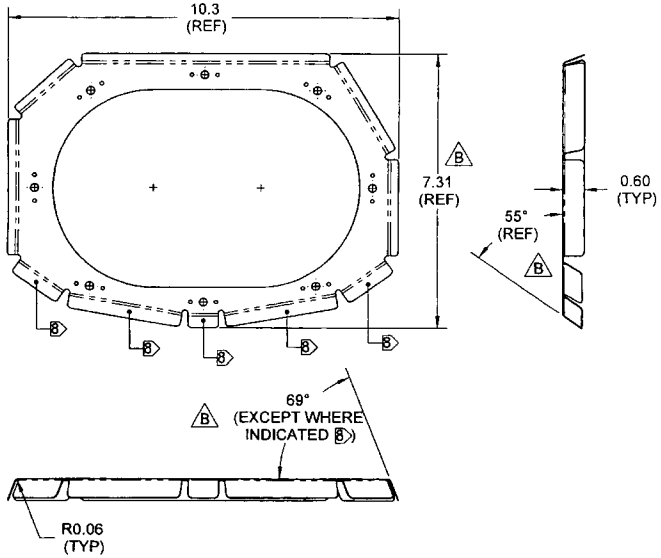
08.03.27

NOTES:
1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) PART IS SYMMETRIC ABOUT ℄
8) WEIGHT: 0.09 lbs

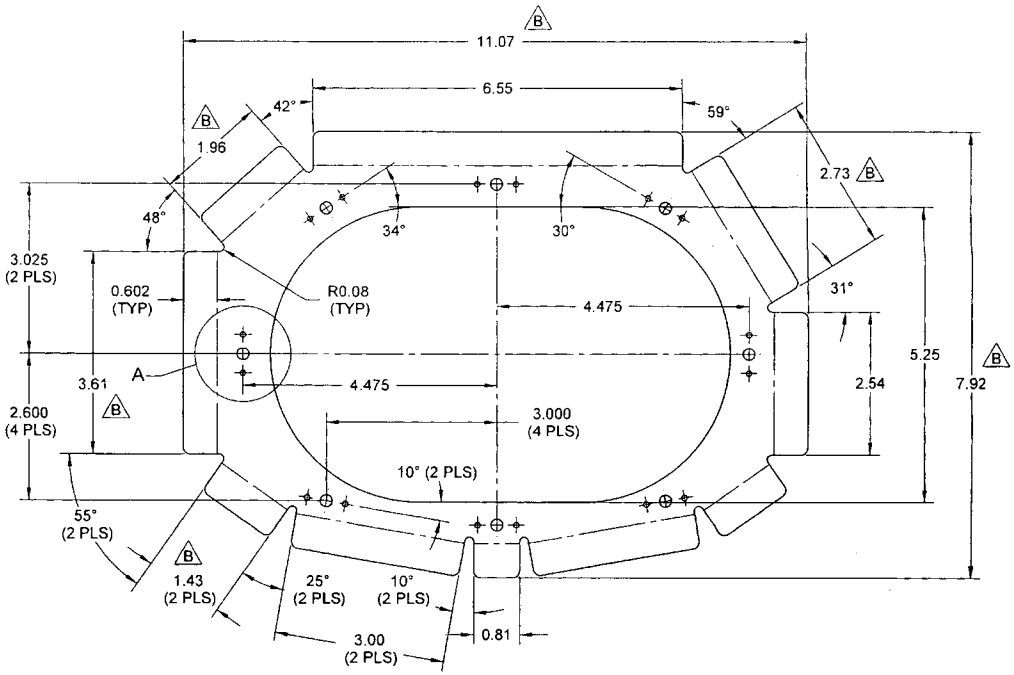
DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D3651 REV. B
MFG. APPR.		SHEET 3 OF 9
APPROVED		TITLE AFT BASE ASSEMBLY SCALE 1:2
DE APPR.		
DATE 08.01.07		

94138

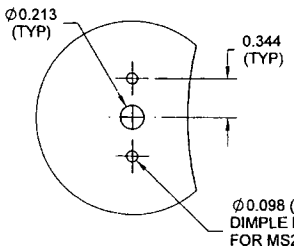




D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)



D3651-3F FLAT PATTERN



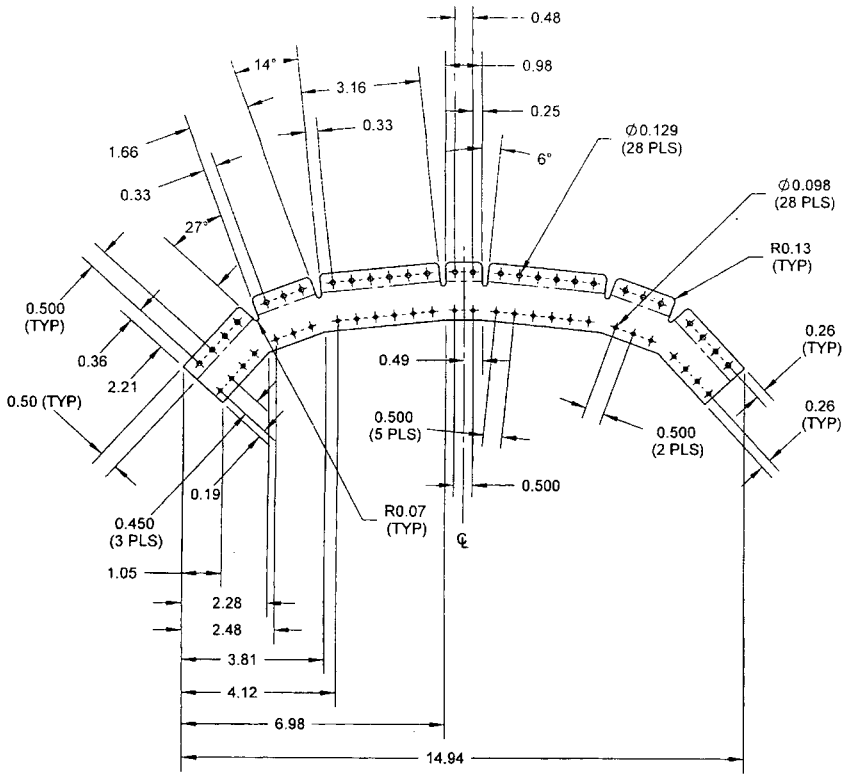
DETAIL A

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019
(REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.27 lbs
8) BEND TO 55° WHERE INDICATED

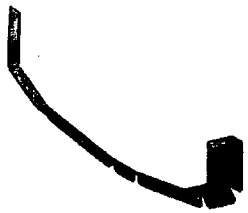
08.03.27 MD

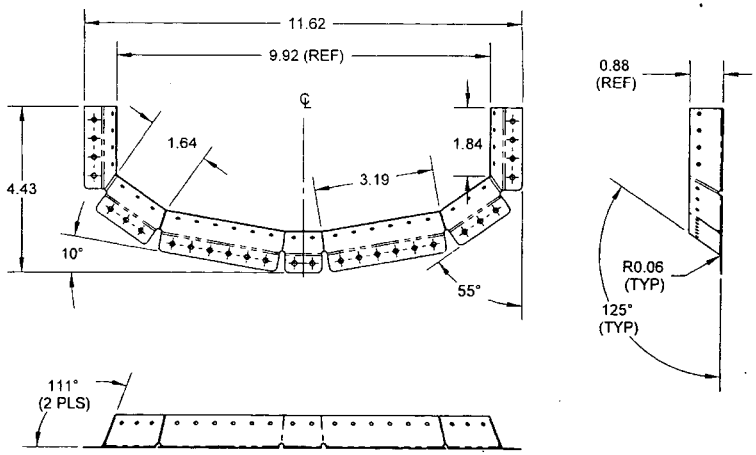
DESIGN	RF	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3651	REV. B
MFG. APPR.			SHEET 4 OF 9
APPROVED		TITLE AFT BASE ASSEMBLY	SCALE 1:2
DE APPR.			
DATE	08.01.07		

94138



D3651-5F FLAT PATTERN (B)





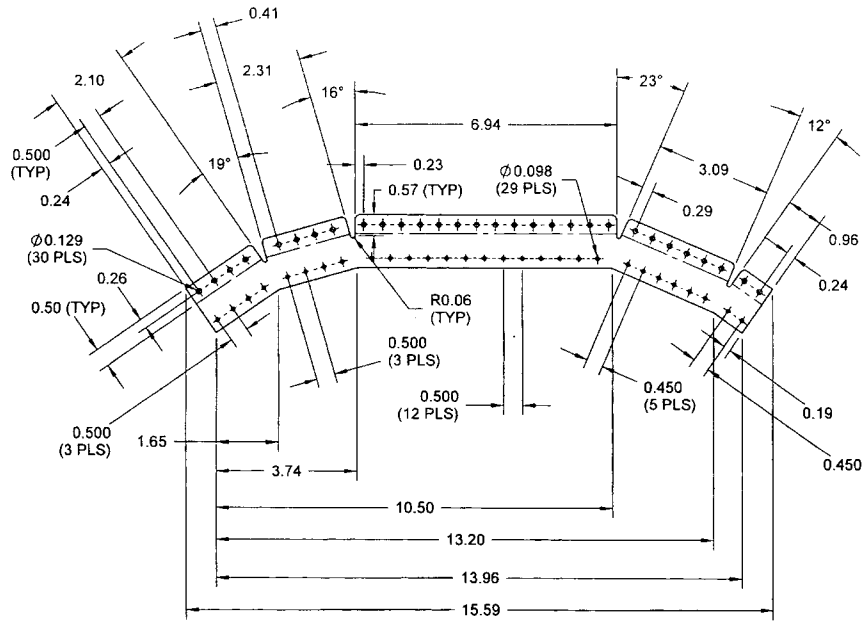
D3651-5 TOP FLANGE BEND DETAIL (B)
(MAKE FROM D3651-5F FLAT PATTERN)

08-03-27 MP

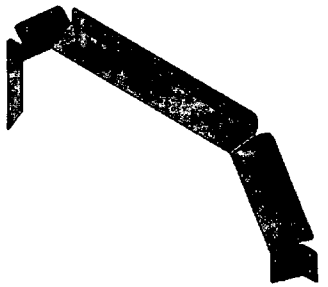
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019
(REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.02 lbs

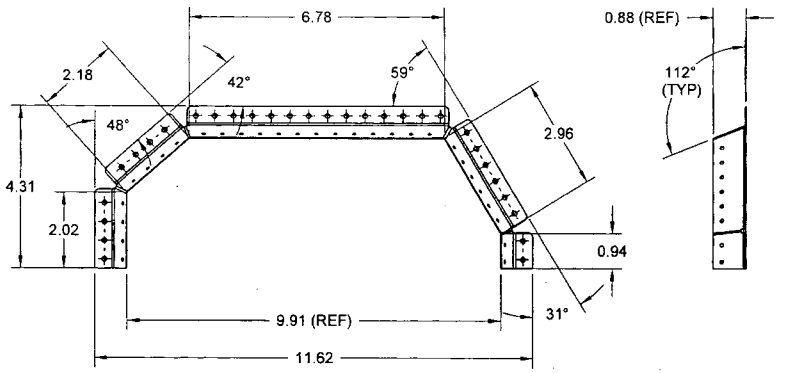
DESIGN	RF	**DART AEROSPACE LTD**
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3651 REV. B
MFG. APPR.		SHEET 5 OF 9
APPROVED		TITLE: AFT BASE ASSEMBLY
DE APPR.		SCALE 1:3
DATE 08.01.07		

94138



D3651-7F FLAT PATTERN (B)





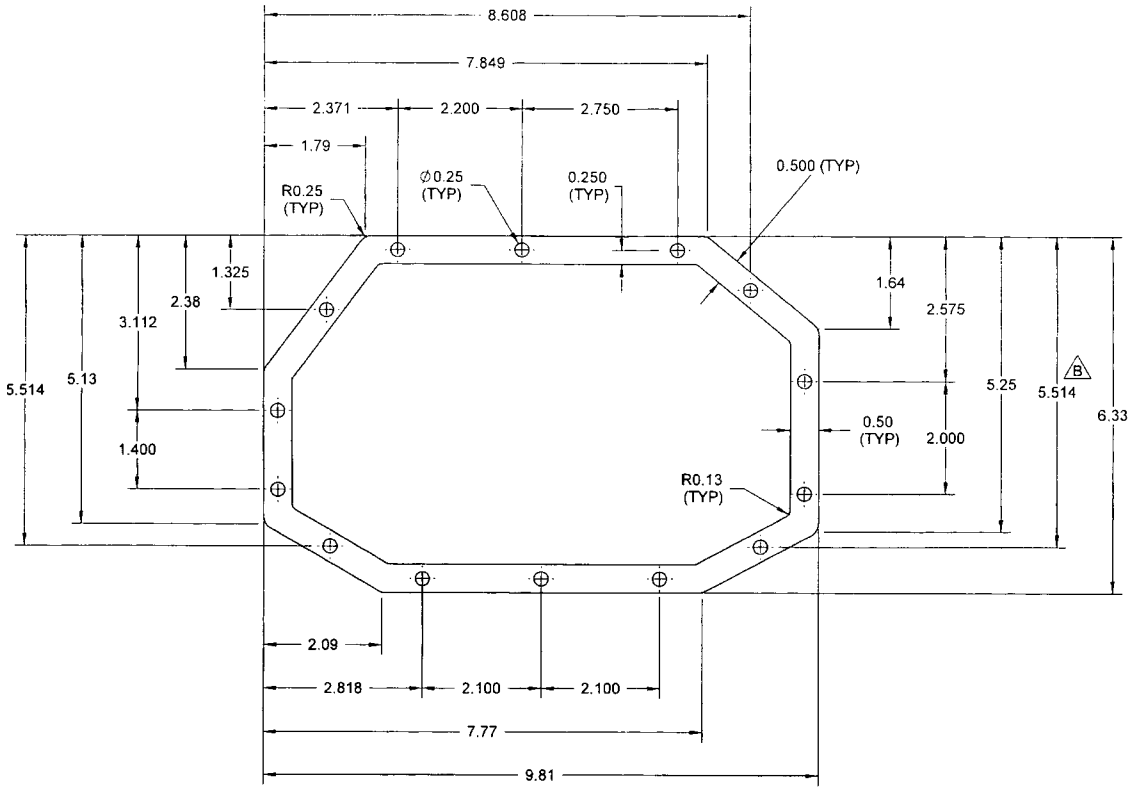
D3651-7 BOTTOM FLANGE BEND DETAIL (B)
(MAKE FROM D3651-7F FLAT PATTERN)

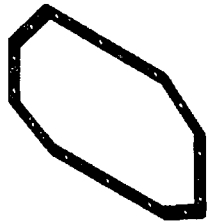
08.03.27 MD

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.02 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D3651 REV. B SHEET 6 OF 9
CHECKED		
MFG. APPR.		TITLE AFT BASE ASSEMBLY SCALE 1:3
APPROVED		
DE APPR.		
DATE	08.01.07	

94138





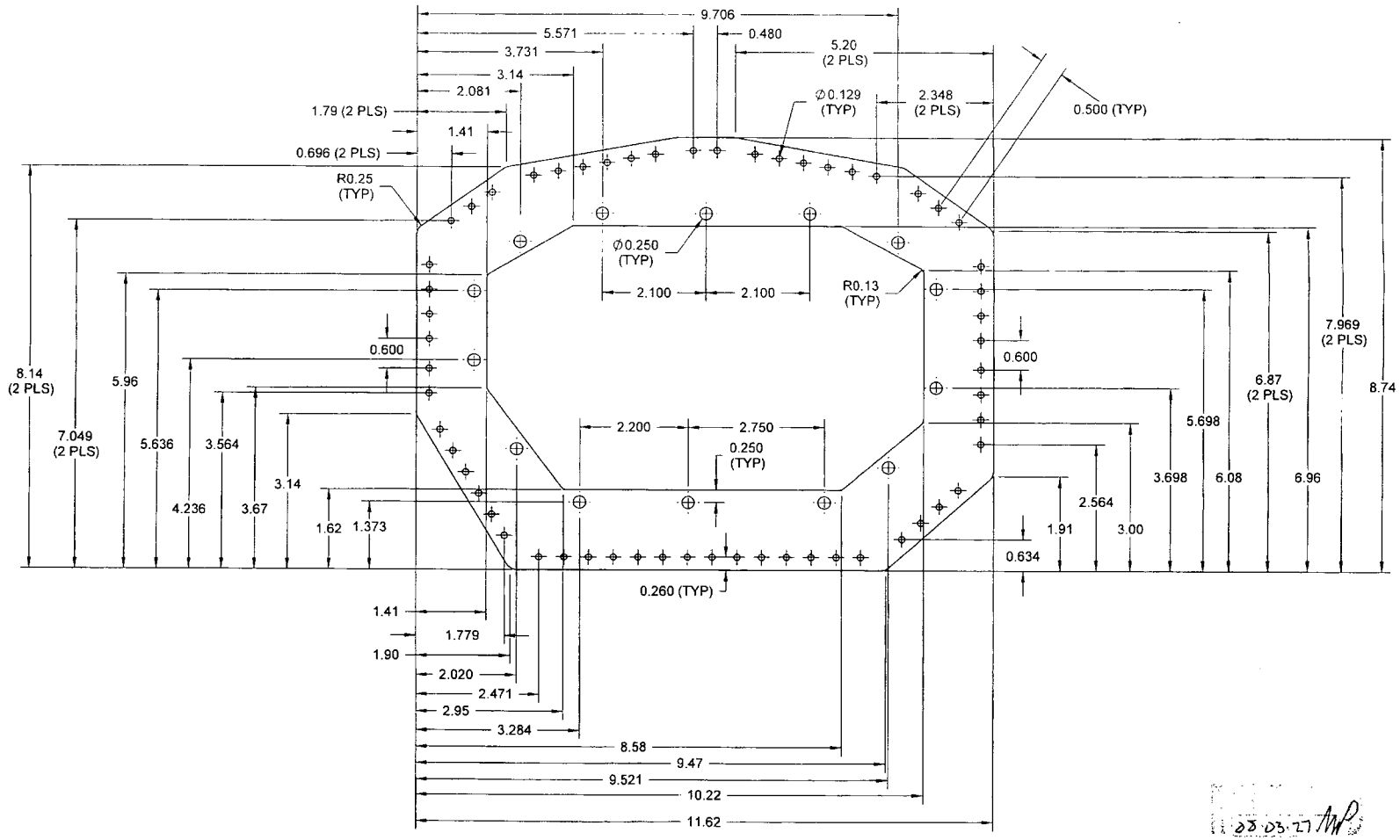
D3651-9 INSIDE DOUBLER

08.03.27 MP

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.07 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D3651 REV. B SHEET 7 OF 9
MFG. APPR.		
APPROVED		TITLE AFT BASE ASSEMBLY SCALE 1:2
DE APPR.		
DATE	08.01.07	

94138

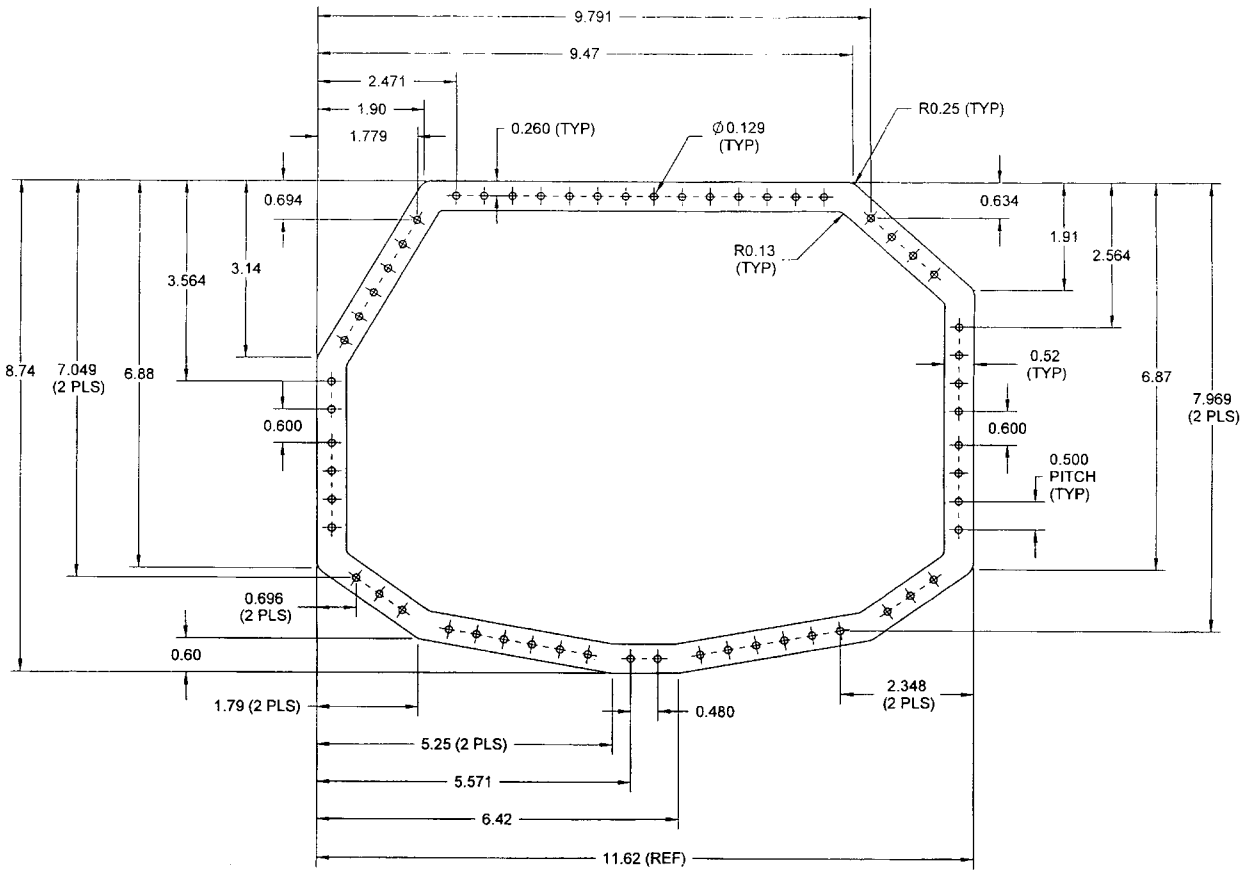


NOTES:
1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.2 lb

D3651-11 GASKET B

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D3651 REV. B
CHECKED		SHEET 8 OF 9
MFG. APPR.		TITLE AFT BASE ASSEMBLY SCALE 1:2
APPROVED		
DE APPR.		
DATE	08.01.07	

94138



D3651-13 OUTSIDE DOUBLER (B)

08.03.27

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.10 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D3651 REV. B SHEET 9 OF 9
MFG. APPR.		
APPROVED		TITLE AFT BASE ASSEMBLY SCALE 1:2
DE APPR.		
DATE	08.01.07	